

Work Order ID 76288

76288

Page 1

Tuesday, November 08, 2011 1:33:36 PM

Item ID: D3911-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Eyebolt Receiver

Start Date: 11/8/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 11/22/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: M.L.J. Date: 11/11/08 Tooling: Date:

Stop *NR2*

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3911	D								

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank to 2.885" long

110

0.00

110

HAAS

HAAS CNC vertical machine #1

Memo

1-MILL as per folio FA917 & dwg,

FOLIO REV:

DWG REV:

2-Deburr as required

issue Proto Archr P/O: 15679
machine as per dwg D3911 REQ.D

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76288

76288

Page 2

Tuesday, November 08, 2011 1:33:36 PM

Item ID: D3911-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Eyebolt Receiver
 Start Date: 11/8/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 11/22/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <i>read</i> *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB <i>Memo</i> <i>read + inspect for transit damage - attached c/c to W10</i>	0.00 0.00							<i>6/4/03/1</i> <i>(10)</i>
130 *130* QC Quality Control	QC8- Inspect parts - second check <i>Memo</i>	0.00 0.00		<i>5/12/03/1</i>		<i>(40)</i>			
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <i>69</i> <i>Memo</i>	0.00 0.00				<i>(10)</i>		<i>12/5/31</i>	

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Work Order ID 76288***76288***

Page 3

Tuesday, November 08, 2011 1:33:36 PM

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Eyebolt Receiver

Start Date: 11/8/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 11/22/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

12/6/4

mf
12-06-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, November 08, 2011 1:33:42 PM

Work Order ID: 76288

76288

Parent Item: D3911-3

D3911-3

Parent Item Name: Aft Eyebolt Receiver

Start Date: 11/8/2011

Required Date: 11/22/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC
AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M303B2000X1.750

Purchased

No

100

f

12.5000

0.26

1.642105

**

M303B2 000X1 750

303 BAR 2" X 1.750"

Location

Loc Qty

Loc Code

MAT050

12.5

118535

12.5

2.5 ~~10~~ 11/12/13

D3911-3P

X 10

142/31 (10)

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



2228 Gladwin Cresent
Ottawa, Ontario
K1B 4S6

Phone # 613-899-2405

Packing Slip

Date	Invoice #
29/05/2012	134

Ship To
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. No.	Ship	Via	FOB	Project
15679	29/05/2012	Federal Express	Archer	

Qty	Item Code	Description
10	Sales	D4151-7P FWD Eyebolt Receiver
10	Sales	D3911-3P AFT Eyebolt Receiver
		HST (ON) on sales



1393 Major Road
Orleans, Ontario
K1E 1H3

Telephone (613) 899-2405
Fax (613) 226-1719

Certificate of Compliance

To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

Po Number	Part Number	Quantities
15679	D4151-7P	10
	D3911-3P	10

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 15679 issued by Dart Aerospace Inc.

A handwritten signature in dark ink, appearing to read 'Alex Mazerolle', is written over a horizontal line.

Alex Mazerolle
President
Archer Precision Inc.
1393 Major Road,
Orleans Ontario
K1E 1H3

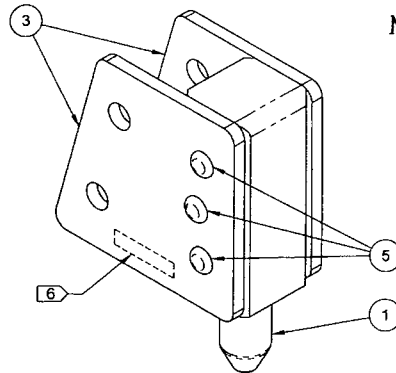
Customer Name			QTY	DWG #	REV	Part Name			Date	Lot#	Job #			
Dart Aerospace			10	D3911-3	D	AFT EYEBOLT RECIEVER			JAN.27/2012		477-13			
Page 1 of 2			Inspection Interval		Special Notes									
			100%											
Item #	DWG. Dim	Tolerance	Operator	QA First Off	QA Final	2	3	4	5	6	7	8	9	10
	Rev	D	✓	✓	✓									
	Mat	304	✓	✓	✓									
	SUB	None												
	Deburr	Yes	✓	✓	✓									
1	1.250	+/- .005	1.251	✓	✓	1.251	1.251	1.251	1.251	1.250	1.251	1.251	1.251	1.250
2	1.250	+/- .005	1.249	✓	✓	1.250	1.250	1.250	1.251	1.249	1.249	1.250	1.249	1.250
3	.625	REF	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
4	.09	+/- .01	.09	✓	✓	PP	PP	PP	PP	PP	PP	PP	PP	PP
5	45°	+/- 1.	45.	✓	✓	PP	PP	PP	PP	PP	PP	PP	PP	PP
6	1.00	+/- .010	1.002	✓	✓	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00
7	0.96	+/- .010	.959	✓	✓	.96	.96	.96	.96	.96	.96	.96	.96	.96
8	2.76	REF	2.762	✓	✓	2.76	2.76	2.76	2.76	2.76	2.76	2.76	2.76	2.76
9	1.000	+/- .005	1.000	✓	✓	PP	PP	PP	PP	PP	PP	PP	PP	PP
10	1.110	+/- .005	1.110	✓	✓	PP	PP	PP	PP	PP	PP	PP	PP	PP
11	.350	+/- .005	.350	✓	✓	.350	.350	.350	.350	.350	.350	.350	.350	.350
12	.257	+/- .005	.256	✓	✓	.256	.256	.256	.256	.256	.256	.256	.256	.256
13	.129	+/- .005	.128	✓	✓	.128	.128	.128	.128	.128	.128	.128	.128	.128
14	4PL	-	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
15	R0.13	+/- .010	.13	✓	✓	PP	PP	PP	PP	PP	PP	PP	PP	PP
16	2PL	-	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
17	R0.19	+/- .010	0.19	✓	✓	PP	PP	PP	PP	PP	PP	PP	PP	PP
18	4PL	-	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
19	.500	+/- .005	.500	✓	✓	.500	.500	.500	.500	.500	.500	.500	.500	.500
20	.500	REF	.500	✓	✓	PP	PP	PP	PP	PP	PP	PP	PP	PP
21	.205	REF	.250	✓	✓	PP	PP	PP	PP	PP	PP	PP	PP	PP
22	.125	REF	.125	✓	✓	.125	.125	.125	.125	.125	.125	.125	.125	.125

Date of Issue July, 13, 2005.

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3911-041	BASKET INSTL STUD ASSY (LOWER)
		X	D3911-043	AFT EYEBOLT RECEIVER ASSY
1	1		D3911-1	BASKET INSTL STUD (LOWER)
2		1	D3911-3	AFT EYEBOLT RECEIVER
3	2		D3911-5	BASKET STUD PLATE
4		2	D3911-7	BASKET PLATE-EYEBOLT RECEIVER
5	3	4	MS20615-4M20	RIVET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76288 MLJ

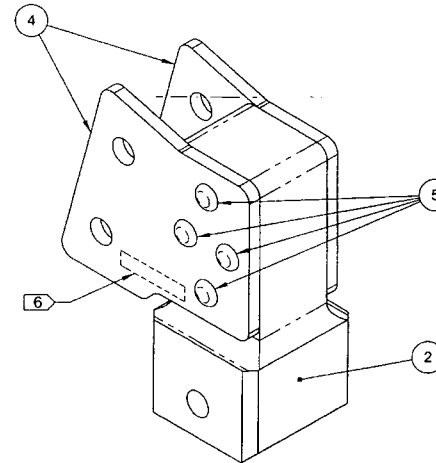
12/05/31



D3911-041 BASKET INSTL STUD ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3911-04X USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 0.63 lbs
-043: 0.99 lbs



D3911-043 AFT EYEBOLT RECEIVER ASSY

RELEASED
2010-08-06

D	0.825 +0.000/-0.010 WAS 0.65 (B1-2).	MB	10.06.22
C	BOM: QTY (2); D4087-1 & MS21209-C810 REMOVED FROM -043 ASSY. WEIGHT UPDATED. D3911-3 REDESIGNED. D3911-043 & D3911-3 DETAIL UPDATED. MTL SPEC ADDED TO NOTES (SHT 2). DIM 0.375 WAS 0.400 (C3-3).	JPH	10.04.06
B	DIAMETER (B3-2) AND DIM ADDED (B2-2) & (C3-2)	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.06.22		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3911** REV. D
SHEET 1 OF 3
TITLE **AFT HARDPOINT, BASKET** SCALE NTS

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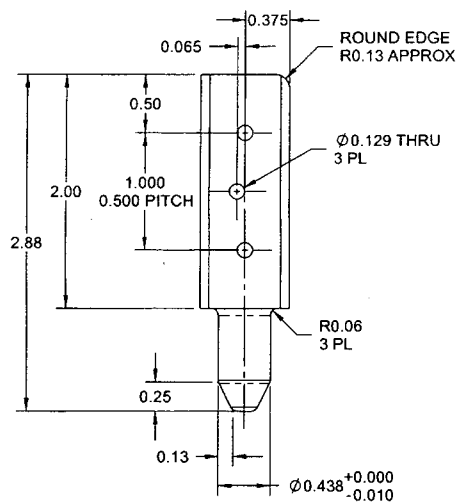
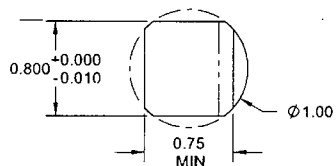
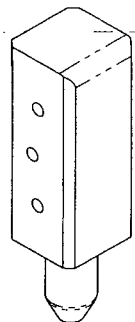
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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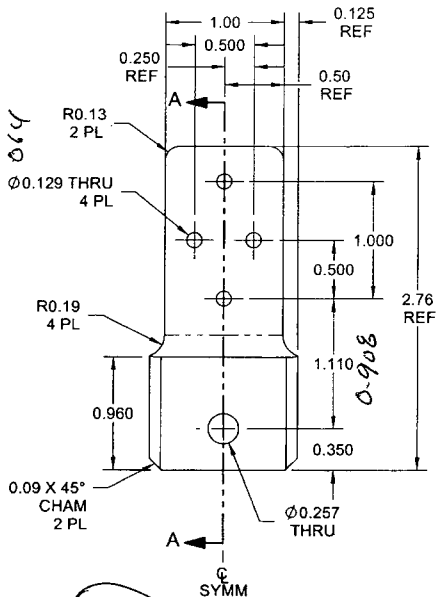
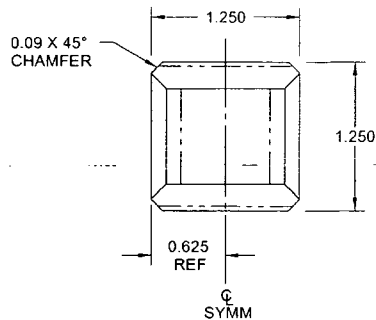
NOTE: Date & initial all entries



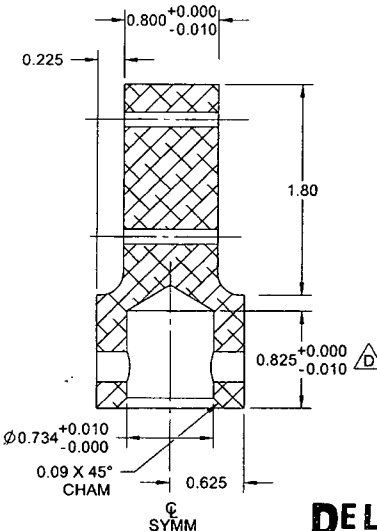
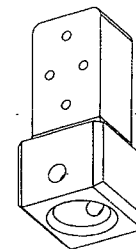
D3911-1 BASKET INSTL STUD (LOWER)

NOTES:

- 1) MATERIAL -1: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -1: 0.36 lbs
-3: 0.71 lbs



D3911-3 AFT EYEBOLT RECEIVER



SECTION A-A

RELEASED
2010-08-04

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. D
MFG. APPR.	JPH	D3911	SHEET 2 OF 3
APPROVED	JPH	TITLE	SCALE
DE APPR. :-	JPH	AFT HARDPOINT, BASKET	NTS
DATE	10.06.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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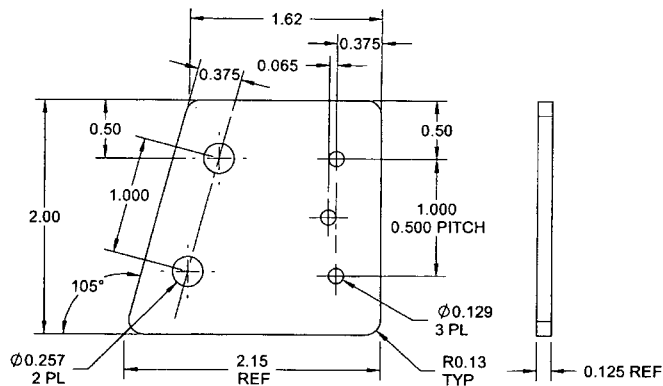
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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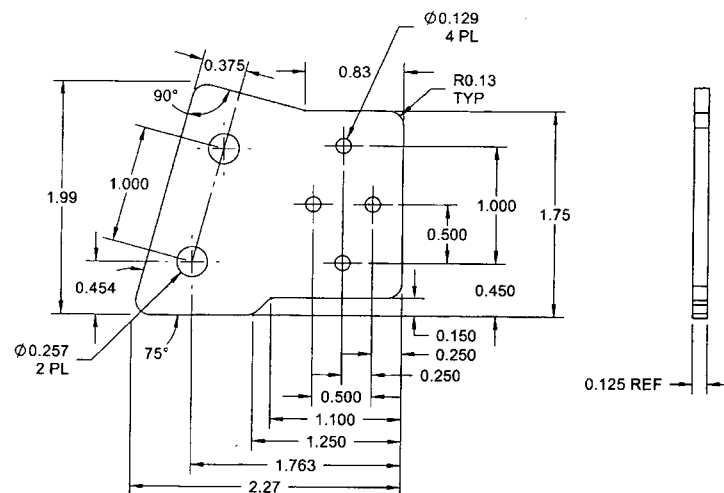
NOTE: Date & initial all entries



D3911-5 BASKET STUD PLATE

NOTES:

- 1) MATERIAL -5 & -7: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.13 lbs
-7: 0.13 lbs



D3911-7 BASKET PLATE-EYEBOLT RECEIVER

RELEASED
2010-08-05
M/S

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3911	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		AFT HARDPOINT, BASKET	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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